

Work Order ID 52354 -1

Tuesday, September 22, 2009 12:26:55 PM

Page 1

Item ID: D3023-1

Accept

Revision ID: A

Item Name: Back Panel

Start Date: 9/23/2009 Start Qty: 6.00

Required Date: 10/9/2009 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

\*\*\*graind direction along 28.100" \*\*\*

2-Deburr if necessary

B 9-11-5

3

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 9-11-5

# Work Order ID 52354

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Item ID: D3023-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Back Panel

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

27 Sotulua

(+3) 4



QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00



Brake NC

Memo

0.00

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using D3017-041 back frame

SB 10/02/04 2-

(3)

11-3-30 (X1)

140

QC5- Inspect part completeness to step on W/O

0.00

Sotulua

(+4)



QC

Memo

0.00

Quality Control



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Setup Start



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Item Name: Back Panel

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5/6) per QSI005 4.3

0.00

Memo

START TIME: \_\_\_\_\_

0.00

□ FINISH TIME: \_\_\_\_\_

□ OVEN TEMPERATURE: \_\_\_\_\_

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

~~N/A~~~~3 10.02.03~~

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Item ID: D3023-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Back Panel

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

w/o

65831 (A)

0.00

Packaging

E/S 11/03/31 (1)

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/31 (1)

11-03-31

# Picklist Print

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Page 1

Work Order ID: 52354



Parent Item: D3023-1RevA



Parent Item Name: Back Panel

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	94.2179	18.1749	10.0		



2024-T3 .032 sheet



18 9-11-5

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

94.21793158

102942

1.5

105555

4.0684

106272

5.3

108595

3

109240

7.02

110778

23.9106316

111699

46.4189

18147

3

113005

113005



DART AEROSPACE LTD		Work Order: 52354
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	130	X			
Ø0.191	+0.005/-0.001	194	X			
1.660	+/-0.010	1.666	X			
0.375	+/-0.010	377	X			
1.340	+/-0.010	1.344	X			
2.375	+/-0.010	2.373	X			
0.375	+/-0.010	373	X			
25.28	+/-0.030	25.28	X			
27.03	+/-0.030	27.03	X			
28.10	+/-0.030	28.10	X			
1.30	+/-0.030	1.297	X			
2.375	+/-0.010	2.373	X			
8.711	+/-0.010	8.712	X			
5.597	+/-0.010	5.598	X			
8.57	+/-0.030	8.571	X			
1.970	+/-0.010	1.967	X			
7.42	+/-0.030	7.420	X			
10.92	+/-0.030	10.92	X			
14.75	+/-0.030	14.75	X			

Measured by: AB
Date: 9-11-5

Audited by: S
Date: 01/11/06

Prototype Approval:	N/A
Date:	N/A

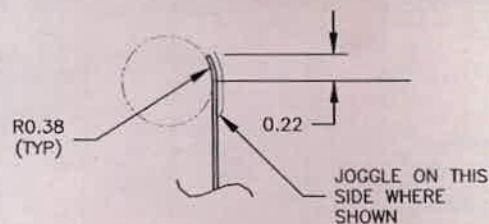
Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AB

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

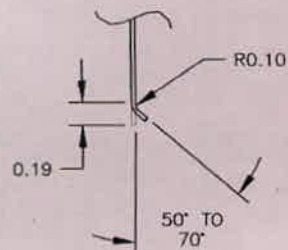
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52354



SECTION A-A  
SCALE 1:1  
(TYPICAL, EXCEPT WHERE SHOWN)

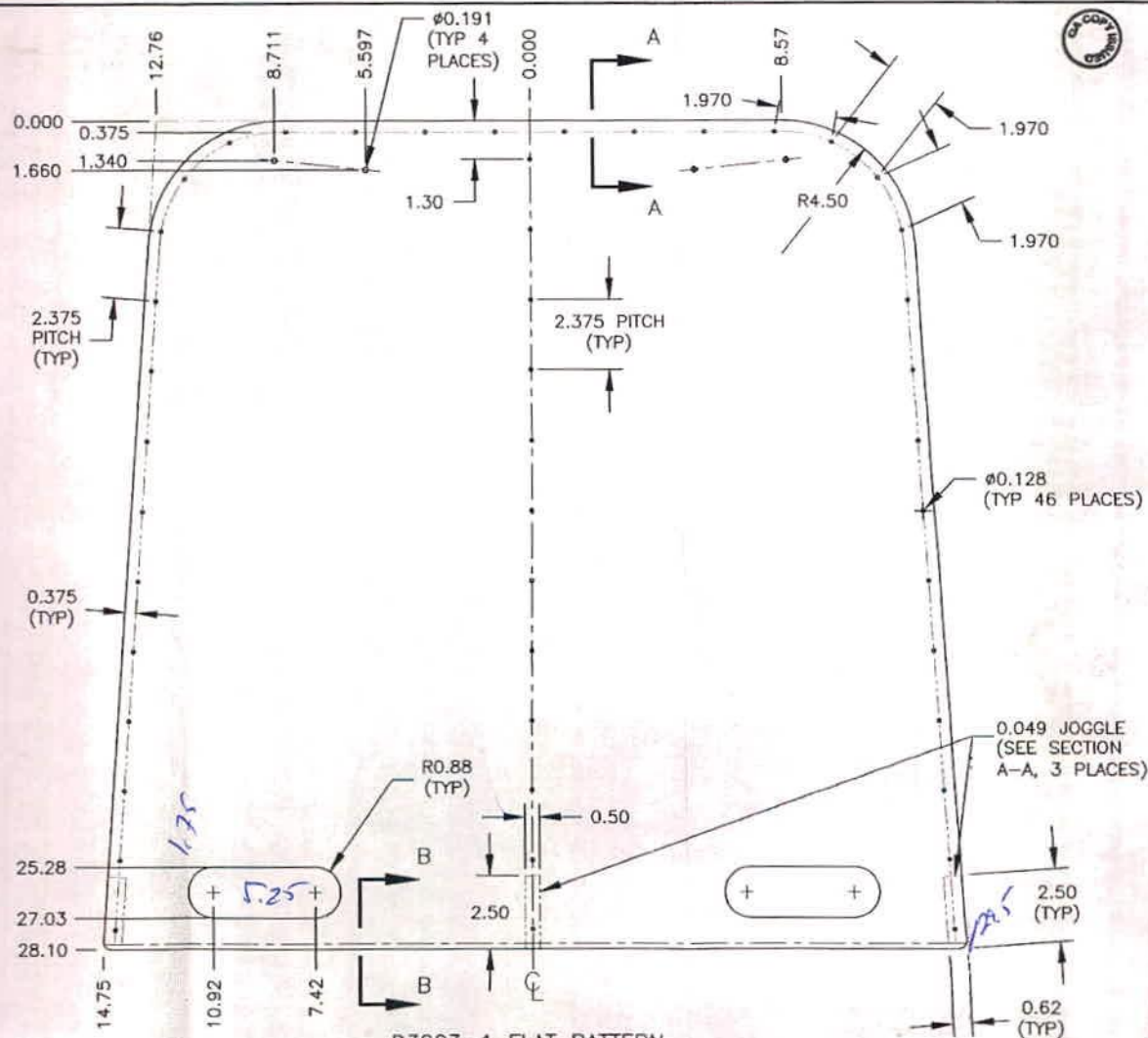


SECTION B-B  
SCALE 1:1  
(BOTTOM EDGE ONLY)



RELEASED  
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4

